

Work Order ID 141140

141140

January 28, 2016 2:25:46 PM

Page 1

Ship March 9

Item ID: D206-628-026BL Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Flight Step R/H For Mid Gear (Ael Blue)
 Start Date: 1/28/2016 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 3/9/2016 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: SK Date: 20160128 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4308	A
IIN-D206-628	G

100	Document Control	0.00	DAS 6 9-89						
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile &type labels per PPP D206-628-026 CHG 001								

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

3 DAS 28 9-89 MAR 09 2016
 3 MAR 01 2016
 DAS 6 9-89
 DAS 27 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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141140

Page 2

January 28, 2016 2:25:46 PM

Item ID: D206-628-026BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Flight Step R/H For Mid Gear (Ael Blue)
 Start Date: 1/28/2016 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 3/9/2016 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC4- 100% Inspect kits for completeness	0.00							
220						3x	DAS 28 9-89	MAR 09 2016	
QC	Memo	0.00							
Quality Control									
230	Identify as per dwg & Stock Location:	0.00							
230						3x	DAS 28 9-89	MAR 09 2016	
Packaging	Memo	0.00							
Packaging	Package per PPP R206-628-026 Location : FG127								
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.01							
Quality Control									

mw MAR 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

January 28, 2016 2:25:51 PM

Work Order ID: 141140

141140

Parent Item: D206-628-026BL

***D206-628-026BL ***

Parent Item Name: Flight Step R/H For Mid Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP rev A 11.05.26 new issue EC verified by:DD
15.10.13 ADDED BL DD VERF:JLM

IPP REV:A

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4308-042BL		Manufactured	No				Each	0.0000	1	3			
D4308-042BL									**				
Step, RH Crew													
D2731-7RG		Manufactured	No				Each	20.0000	2				
D2731-7RG									**				
Mounting Lug													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST531			20					
					129256			20					
D3394-3RG		Manufactured	No				Each	30.0000	2	6			
D3394-3RG									**				
Lug													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST528			2					
					114503			2					
					ST531			8					
					140887			8					
					ST532			20					
					129260			20					
D4309-1		Manufactured	No				Each	22.0000	2	6			
D4309-1									**				
Bushing													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST091			22					
					137723			22					

MAR 01 2016

Picklist Print

January 28, 2016 2:25:51 PM

Work Order ID: 141140

141140

Parent Item: D206-628-026BL

***D206-628-026BL ***

Parent Item Name: Flight Step R/H For Mid Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 3.00

Required Qty: 3.00

AN4-11A Purchased No Each 122.0000

3

AN4-11A

BOLT

DAS
28
9-89

Location	Loc Qty	Loc Code
FG	20	
120731	20	
over003	100	
M133234	100	12
ST344	2	
M128362	2	

** 4 12

DAS
6
9-89

AN4-12A Purchased No Each 142.0000

3

AN4-12A

Bolt

DAS
28
9-89

Location	Loc Qty	Loc Code
FG	10	
120423	10	
over003	100	
m133990	100	12
ST344	32	
m131957	32	

** 4 12

DAS
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9-89

AN4-15A Purchased No Each 351.0000

3

AN4-15A

Bolt

DAS
28
9-89

Location	Loc Qty	Loc Code
GA	40	
120449	40	
over003	100	
m134055	100	
ST343	211	
m133284	3	
m133769	208	6

** 2 6

DAS
6
9-89

MAR 01 2016

Picklist Print

January 28, 2016 2:25:51 PM

Page 3

Work Order ID: 141140

141140

Parent Item: D206-628-026BL

***D206-628-026BL ***

Parent Item Name: Flight Step R/H For Mid Gear (Ael Blue)

Start Date: 1/28/2016

Required Date: 3/9/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042-4 MS21042L4 Purchased No

Each 2.0000

MS21042-4

Nut / use MS21042L4

DAS
28
9-89

Location

Loc Qty

Loc Code

ST304

2

9063

2

Each

5,435.000

NAS1149D0463J

Purchased

No

NAS1149D0463.J

WASHER

Location

Loc Qty

Loc Code

GA

397

M129390

41

M132035

356

ST260a

2000

M134039

2000

ST263

1689

M134039

1689

ST269

1349

M130799

361

M132317

100

M132677

888

DAS
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9-89

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133769

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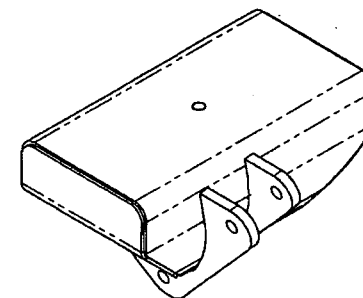
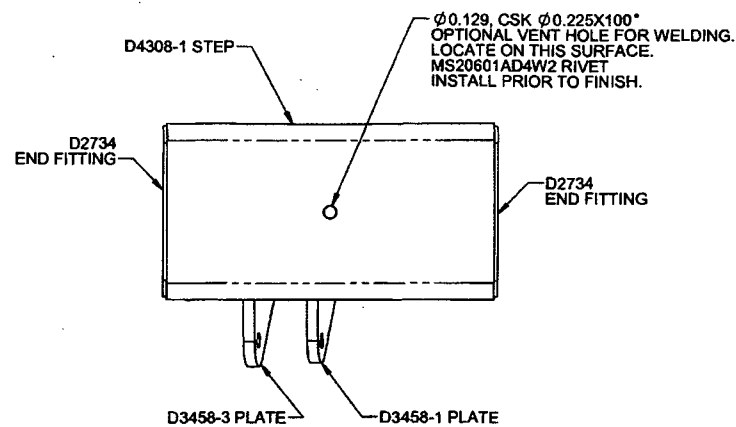
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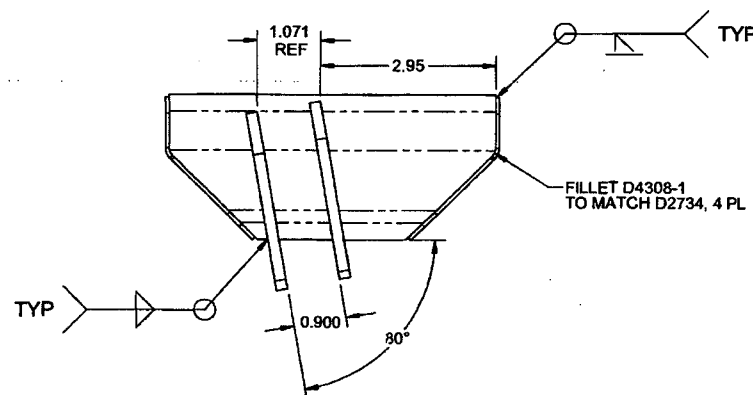
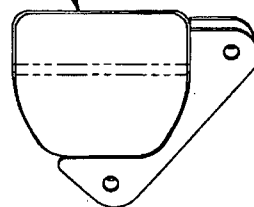
DAS
27
9-89

MAR 01 2016

ITEM	QTY	P/N	DESCRIPTION
1	X	D4308-041	STEP, LH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-041 STEP, LH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

RELEASED
2011-05-26

20160128 SA 141140

REV.	NEW ISSUE	DESCRIPTION	CP	10.12.17
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.12.17			

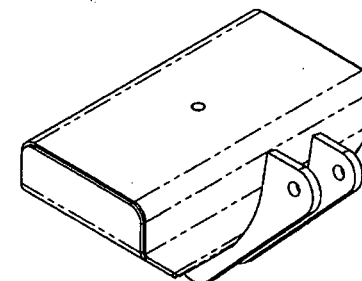
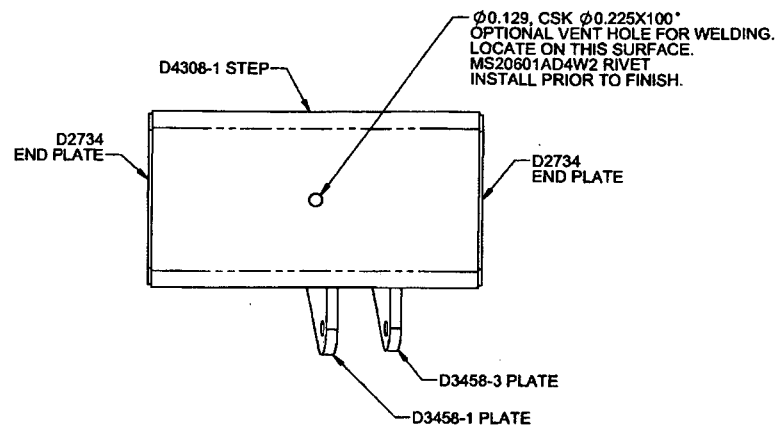
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4308** REV. A
SHEET 1 OF 3

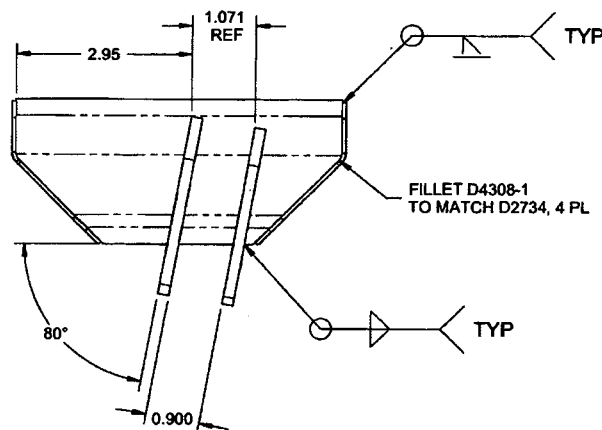
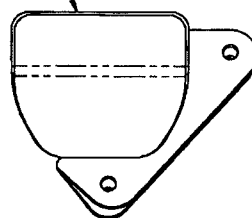
TITLE **STEP, CREW** SCALE NTS

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ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4308-042	STEP, RH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-042 STEP, RH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4308	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
DATE	10.12.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2011-05-24
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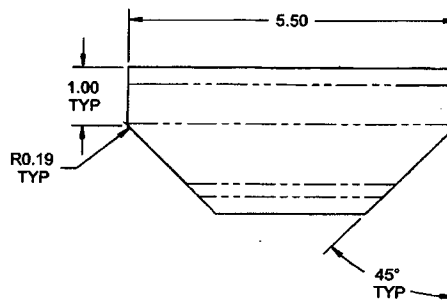
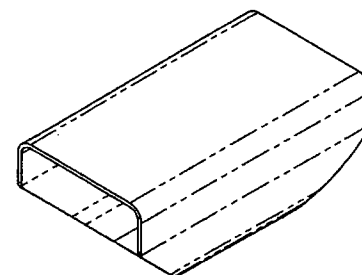
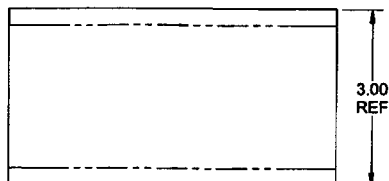
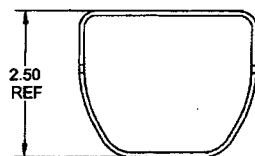
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A

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**D4308-1 STEP**

RELEASED
2011-05-20
MD

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	MD	D4308	SHEET 3 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	STEP, CREW	NTS
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Work Order ID 141140

January 28, 2016 2:25:46 PM

141140

Page 1

Item ID: D206-628-026BL

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Flight Step R/H For Mid Gear (Ael Blue)

Stop

NS2

Start Date: 1/28/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 3/9/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: SM

Date: 20160128

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4308

A

IIN-D206-628

G

DAS

100

Document Control

0.00

9-89

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D206-628-026
CHG 001

MS

MAR 01 2016

3

DAS

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110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

MAR 01 2016

REFERENCE ONLY

DART AEROSPACE USA, INC.

DAS
28
9.89
IIN-D206-628
Page 19 of 19

5.4 CREW STEP PARTS LIST

Qty -015	Qty -016	Qty -025	Qty -026	Qty -035	Qty -036	Part Number	Description
X						D206-628-015	CREW STEP, LH 206A/B
	X					D206-628-016	CREW STEP, RH 206A/B
		X				D206-628-025	CREW STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-026	CREW STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-035	CREW STEP, LH 407
					X	D206-628-036	CREW STEP, RH 407
				2	2	D2731-3RG	MOUNTING LUG
2	2	2	2			D2731-7RG	MOUNTING LUG
				2	2	D3394-1RG	MOUNTING LUG
2	2	2	2			D3394-3RG	MOUNTING LUG
		1		1		D4308-041	CREW STEP, LH
			1		1	D4308-042	CREW STEP, RH
2	2	2	2	2	2	D4309-1	BUSHING
1						D4357-041	CREW STEP, LH
	1					D4357-042	CREW STEP, RH
		4	4			AN4-11A	BOLT
4	4	4	4	4	4	AN4-12A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

5.5 MAINTENANCE STEP PARTS LIST

Qty -017	Qty -018	Qty -027	Qty -028	Qty -037	Qty -038	Part Number	Description
X						D206-628-017	MAINTENANCE STEP, LH 206A/B
	X					D206-628-018	MAINTENANCE STEP, RH 206A/B
		X				D206-628-027	MAINTENANCE STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-028	MAINTENANCE STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-037	MAINTENANCE STEP, LH 407
					X	D206-628-038	MAINTENANCE STEP, RH 407
2	2			2	2	D2731-3RG	MOUNTING LUG
		2	2			D2731-7RG	MOUNTING LUG
2	2			2	2	D3394-1RG	MOUNTING LUG
		2	2			D3394-3RG	MOUNTING LUG
2	2	2	2	2	2	D4309-1	BUSHING
		1		1		D4342-041	MAINTENANCE STEP, LH
			1		1	D4342-042	MAINTENANCE STEP, RH
1						D4358-041	MAINTENANCE STEP, LH
	1					D4358-042	MAINTENANCE STEP, RH
4	4	4	4	4	4	AN4-12A	BOLT
		4	4			AN4-13A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

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Revision: G
Date: 11.02.25